

Date: Monday, 18/08/2008 3:24:14 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 41297		
Estimate Number	: 10022		
P.O. Number	:	Part Number	: D205634011
This Issue	: 18/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 40377	Drawing Revision	: N/A
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 08/09/2008
Checked & Approved By	: <u>JUD 08.8.18</u>	Qty:	1 Um: Each
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ Est Rev:Q 08-08-12 now @ chg 006 (DSI 9417) DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JUD 08.8.28



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG006

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	41297A	SKID TUBE ASSEMBLY
-----	--------	--------------------



Comment: Sub-Component SKID TUBE ASSEMBLY

1 x D205-634-041 Batch 41297A

4.0	K10003	Saddle, D205-634-011
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	<u>46194</u>

8/9/12

(X)

SY

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

0809-12 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:24:14 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 41297

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



②

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: h

8/9/10

Sy

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-12

B41297

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:24:39 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 41297A		
Estimate Number	: 10023		
P.O. Number	:	Part Number	: D205634041
This Issue	: 18/08/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2580 REV D
First Issue	: 18/08/2008	Project Number	: N/A
Previous Run	: 41265	Drawing Revision	: D
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 08/09/2008
Checked & Approved By	: <u>JLP 08.8.18</u>	Qty:	1 Um: Each
Comment	: Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ		
	Est Rev: O 06.02.28 Added paperwork EC		
	Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

2.0	D25001190	Ext'n -I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B. 40150

AWN 8-8-20

3.0	D2596	Web, 205 Skidtube
-----	-------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	41261

85 08-08-25

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

- AWM 8-8-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RT 08-08-29

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	108801	
Sikaflex expire date: 8-10-01			
Start Time: 1:00		Date: 08-08-25	
Fin Time: 7:30		Date: 08-08-26	

RT 08-08-29

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

RT 08-08-26

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

JD 8-8-17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/08/27

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>338392 BE 08/08/28</i>

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>40831</i>

ET 08-08-27

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m 108708

BE 08/08/28

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m 108708

BE 08/08/28

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

Job 8-8-28

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

Job 8-9-2

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Monday, 18/08/2008 3:24:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/09/03 (X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-L 08/09/03 (1X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:00

OVEN TEMPERATURE:

320°

FINISH TIME:

1:30

FL 08/09/03 (1)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-09 (X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B39562

M-L

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M100188

M-L 08/09/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M 105793

M-h

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch:

M 105819

M-h

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch:

M 109148

M-h

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch:

M 109147

M-h

24.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 41336

M-h

25.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B 40401

M-h

26.0

D35661

Gasket



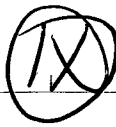
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B 41466

M-h 08/09/09



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:24:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B41335

M. L.

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B41463

M. L.

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B41465

M. L.

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B41464

M. L.

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch:

B29908

M. L.

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch:

B38950

M. L.

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(1X)

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M108801

M. L. 08/09/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:24:40 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 41297A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 08/10

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 08/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M107892

1A

M-L 08/04/04

34.0

QC5

INSPECT WORK TO CURRENT STEP



Solo 04/10 @



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



2

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev: PPP 41297

8/9/10

51

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 #

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FORSHOP COPY WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 41297A

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RELEASED
07-06-28-11

Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a circular base plate with a central hole and a rectangular cutout. The drawing includes the following dimensions and labels:

- Dimensions:**
 - 0.208 (Top center)
 - 0.40 (Bottom center)
 - 0.40 (Left side, vertical dimension)
 - 0.40 (Right side, vertical dimension)
- Labels and Callouts:**
 - DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES) (Top left)
 - AN3-SA BOLT (1) (Left side, pointing to the central hole)
 - AN960JD10L WASHER (1) (2 PLACES) (Left side, pointing to the central hole)
 - D2855 CAP (Left side, pointing to the central hole)
 - SEAL WITH SIKAFLEX-241/-291 (Top right)

D2579 SPACER

WEB (REF)

.130 (REF)

10 PLACES)

AFTER PERFORM
1. CHA
2. INS
3. WEI
4. C'B'

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

37.50
DISTANCE TO AFT END
OF D2596 WEB
3 7
REFER TO DETAIL A
1.750 1.750
8.750
17.375
26.000
34.188
57.313 (REF)
7 EQUAL SPACES
8.188 PITCH
38.0 91.500 190.0
(D2500-1)
#0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

D

P P P P P P P

B

1.5

1.5

1.5

REFER TO DETAIL C

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

AN3C4A BOLT (1)

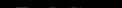
AN960C10L WASHER (1)

(50 PLACES)

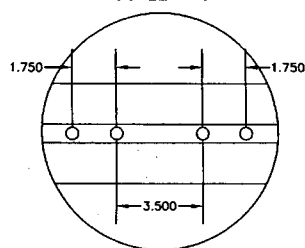
DESIGN	J	DRAWN BY	
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i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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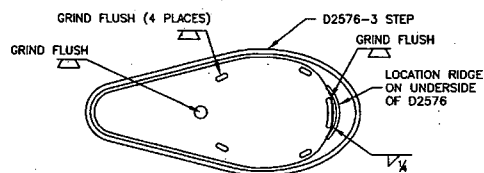
DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 0
		02580	SHEET 2 OF 3
DATE			SCALE
07.02.27	205 SKIDTUBE ASSEMBLY		1:24

DETAIL E
SCALE 5:24

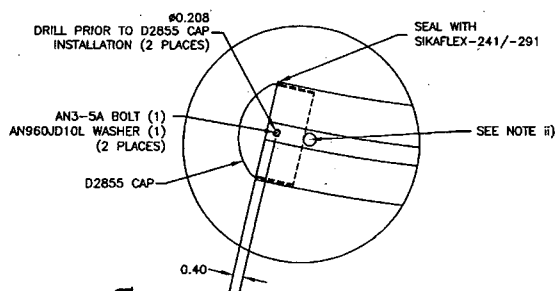


RELEASED
07.02.28

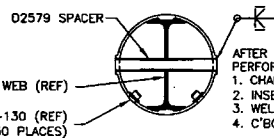
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

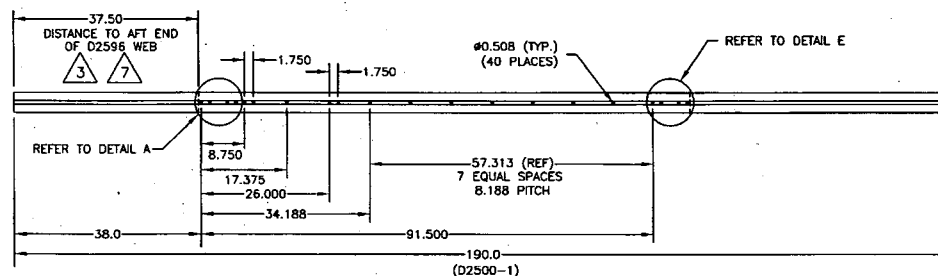


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

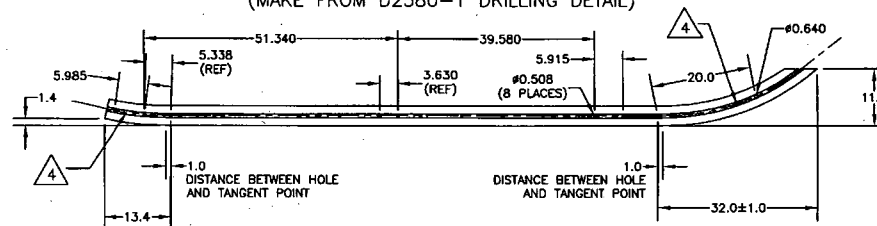
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

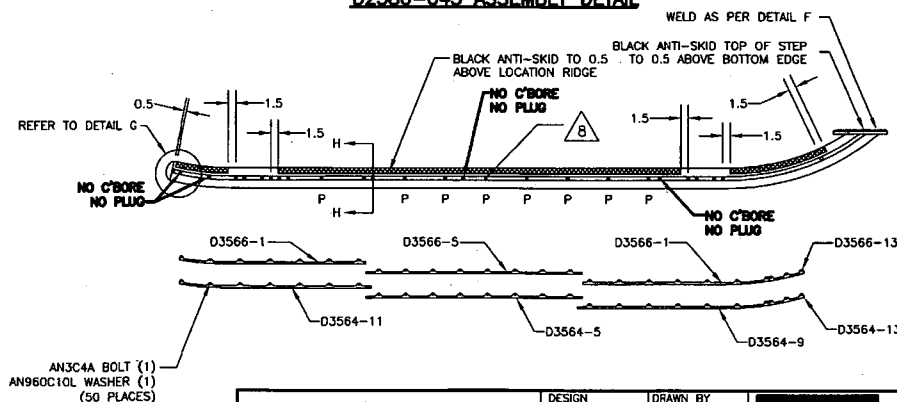
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN PH	DRAWN BY PH	DART	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, ENGLAND
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. 0 SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

NO. 171

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 41300
Part number: D205 634 Cyl
Description: 205 shield tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pet Dal Date of Test Coupon 08-09-03
Welder Barclay Elliot Date of Test Coupon 08-09-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld